



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D117-762-041
Job Sheet 192998



Part No: D117-762-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/5/19

Job Tracking No:

Due Date: 4/24/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3582 REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA as per dwg DD verF by:EC IPP REV:C 15.06.11 AS PER CHG002 DD VERF:JLM IPP REV:D 16.02.05 DWG REV.C (ecn16-514) DD VERF:JLM IPP REV:E 17.01.17 as per dwg REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	Skidtubes - 1	1 pcs	4/24/19		0.00	3.47	Skidtubes - 1		DD
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
140	Skidtubes - 2 - B4B	1 pcs	4/24/19		0.00	3.47	Skidtubes - 1 - B4B		BE
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
150	QC 10	1 pcs	4/24/19		0.00	0.00	QC 10 - 10		D 19-01-15 / DAS
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
160	QC 5	1 pcs	4/24/19		0.00	0.00	QC 5 - 10		63 9-19
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		



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Container No: S171580



Part: D117-762-041

Job No: 192998

Serial No/Batch: S171580

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR01853SE 18/10/17, 16, STC LoA RDIMS-4374899 08/09

Plex 4/5/19 9:58 AM Dart.lajeunesse.marie

					QC 5 - 49					
					QC 5 - 51					
					QC 5 - 58					
					QC 5 - 68					
					QC 5 - 9	PD 19.04.15				
					QC 5 - 50					
					QC 5 - 30					
					QC 5 - 40					
					170 Handfinish - 1-1 Chemical-B4B	1 pcs	4/24/19	0.00 0.97	Handfinish - 1 - 1 - B4B	
Handfinish - 1 - 2 - B4B										
Handfinish - 1 - 3 - B4B										
Handfinish - 1 - 4 - B4B										
Handfinish - 1 - 5 - B4B										
Handfinish - 1 - 6 - B4B										
Handfinish - 1 - 7 - B4B										
Handfinish - 1 - 8 - B4B										
Handfinish - 1 - 9 - B4B										
Handfinish - 1 - 10 - B4B	DR19/04/16									
Handfinish - 1 - 11 - B4B										
Handfinish - 1 - 12 - B4B										
Handfinish - 1 - 13 - B4B										
Handfinish - 1 - 14 - B4B										
Handfinish - 1 - 15 - B4B										
Handfinish - 1 - 16 - B4B										
Handfinish - 1 - 17 - B4B										
Handfinish - 1 - 18 - B4B										
Handfinish - 1 - 19 - B4B										
Handfinish - 1 - 20 - B4B										
Handfinish - 1 - 21 - B4B										
Handfinish - 1 - 22 - B4B										
180 QC 7	1 pcs	4/24/19	0.00 0.00	QC 7 - 10						
				QC 7 - 13						
				QC 7 - 14						
				QC 7 - 15						
				QC 7 - 17						
				QC 7 - 18						
				QC 7 - 19						
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				QC 7 - 34						
				QC 7 - 36						
				QC 7 - 37						
				QC 7 - 41						
				QC 7 - 47						
				QC 7 - 48						
				QC 7 - 51						
									Plex 4/5/19 9:58 AM Dart.lajeunesse.mari	

				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	MBH
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
190 Skidtubes - 3 - B4B	1 pcs	4/24/19	0.00 3.47	Skidtubes - 1 - B4B	BO
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
200 QC 10	1 pcs	4/24/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	DAS
				QC 10 - 24	24
				QC 10 - 43	9-89
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
210 QC 5	1 pcs	4/24/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
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				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	MAY 01 2019
				QC 5 - 9	DAS
				QC 5 - 50	68
				QC 5 - 30	9-89
				QC 5 - 40	
215 Handfinish - 2-1 Pressure- B4B	1 pcs	4/24/19	0.00 0.97	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	DR 19/05/01
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
220 Powdercoat - 1 White Gl(A)- B4B	1 pcs	4/24/19	0.00 0.26	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	DR 19-5-2
				Powdercoat - 4 - B4B	
230 QC 3	1 pcs	4/24/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	UL 14-5-2
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	

Plex 4/5/19 9:58 AM Dart.lajeunesse.marie

					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
250	Handfinish - 4-1-Assembly-B4B	1 pcs	4/24/19	0.00 0.97	Handfinish - 4 - 1 - B4B	M 14-5-2
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
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					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
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					Handfinish - 4 - 2 - B4B	
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					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
260	QC 5	1 pcs	4/24/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	DAS
					QC 5 - 68	MAY 03 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
270	Packaging 3-1 - Stock - B4B	1 pcs	4/24/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
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				Packaging 3 - 16 - B4B	
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				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS 21
				Packaging 3 - 36 - B4B	9-89 MAY 03 2019
275 DC - 1 - B4B	1 pcs	4/24/19	0.00 0.00	DC - 1 - B4B	DAS 21
				DC - 2 - B4B	21
280 QC 21 - FG	1 pcs	4/24/19	0.00 0.00	QC 21 - FG - 21	9-89 MAY 03 2019
				QC 21 - FG - 70	DAS
				QC 21 - SA - 53	21 MAY 03 2019

Part Op 130 - Skidtubes-1 (Skidtubes) 1-Cut Aft end using DT8185 2-Deburr ends 3-Drill Aft Cap holes using DT8678 *** OPEN
 Descriptions: AFT CAP HOLE TO .187" *** 4-Locate DT 8973 from aft cap holes & Drill Ground wire hole on top of Tube. 5-Install 3/16 cleco in Ground wire hole, then drill all X-Bolt holes using 3/16" drill. 6-Drill pilot holes for wearplates using DT8900 7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582. 8-Drill holes for D5520-1 doubler using DT10309 A & B, locating from 4th and 5th crossbolt holes from aft using .1875 clekos. Spot drill tube using #20 drill (note 10). Remove DT10309 B. Re-install DT 10309 A drill thru tube and doubler using #20 drill (note 10), cleco as you go. Remove .1875 clekos and open holes in tube and doubler to 0.750". Remove doublers and identify orientation. 9-Deburr doubler and doubler holes in skid tube. 10-Countersink doubler holes in skid tube as per Dwg. detail J and note 12 -Touch up alodine on D5520-1 doublers. 11- open ground wear holes to 0.391" as per section B-B 12-Open Aft Cap holes using .209" drill. 13-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size. 12-Do not open holes of section G-G to finishes size.

140 - Skidtubes-1 (Skidtubes) 1-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD

Batch: 138989 2-Grind flush

150 - QC10 (QC10- Inspect visual per QSI004- ground welds)

160 - QC5 (QC5- Inspect part completeness to step on W/O)

170 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)

180 - QC7-1 (QC7-Inspect Chemical Conversion Coat)

190 - Skidtubes-1 (Skidtubes) ***MASK OFF HOLES OF SECTION F-F (DO NOT C'SINK) 1-Open X-Bolt holes to finish size as per Dwg D3582, sections D-D, E-E, G-G as per Dwg. 2-Counter Sink X-BOLT holes as per Dwg D3582 D-D, E-E and G-G.***Do NOT countersink holes of section F-F). 3-Deburr and blow out chips from inside of tube, prep. tube for welding. 4-Install doublers using DT10309 B. Shave rivets as required. 5-Bond web as per Dwg D3582 & QSI 015 A/R 241 Sika Flex Batch: 5163437 Exp Date: 04/12/2019 6- Swage x-bolt spacer as per dwg and Section F-F QSI002. 7-Weld x-bolt spacers as per Dwg D3582 section D-D, E-E and G-G. A/R AL ROD

Batch: 138989 8-Grind welds flush

200 - QC10 (QC10- Inspect visual per QSI004- ground welds)

210 - (QC5- Inspect part completeness to step on W/O)

215 - HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Touch-up alodine as per QSI

220 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

230 - (QC3- Inspect Part Finish)

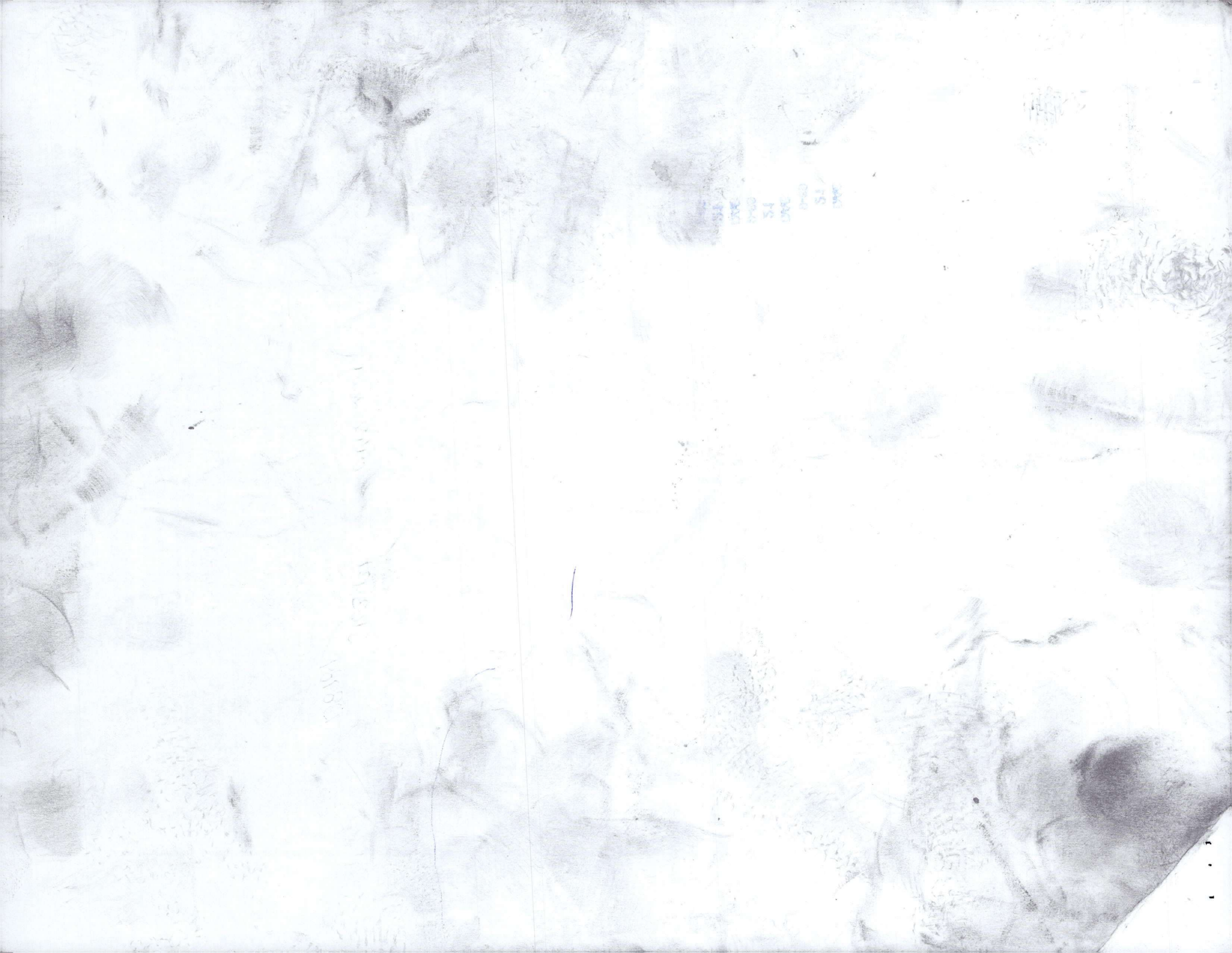
250 - HandFinish4 (Assemble as per dwg) 1-Inspect for Foreign objects 2-Install Aft cap as per Dwg D3582, Detail "C" A/R 241 Sika Flex Batch: 5179347 Exp Date: 12-12-2 3-Install Wearplates as per Dwg D3582 , Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582 *****Do not install bolts where indicated on Dwg(Note #6)***** 4- Wing Walk as per Dwg D3582 and QSI 005 4.4

260 - (QC5- Inspect part completeness to step on W/O)

270 - Identify and pack for shipping as per PPP D117-762-041 Location :FG081

275 - (Document Control) Photocopy bluefile & type labels per PPP D117-762-041 CHG003

280 - (QC21- Final Inspection - Work Order Release)



Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3582-1-BENT	Skidtube Assembly BK117	1 pcs (1 ea)	130-Skidtubes - 1	5144991
D5520-1	Doubler	2 pcs (2 ea)	130-Skidtubes - 1	5146905
D2964	Cap	1 pcs (1 ea)	140-Skidtubes - 2 - B4B	5146305
CR3212-5-05	Rivet	68 pcs (68 ea)	190-Skidtubes - 3 - B4B	5157507
D2971	Cross Bolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5090635
D3584-1	Web	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5145745
D3662-1	Crossbolt Spacer	3 pcs (3 ea)	190-Skidtubes - 3 - B4B	5148281
D3662-3	Crossbolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5148281
D5304-1	Crossbolt Spacer	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	5148281
ALS4-1032-130	Rivnut	36 Ea (36 ea)	250-Handfinish - 4-1-Assembly-B4B	5087257
ALS4-428-165	Insert	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5147561
AN3-5A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5095480
AN3C4A	Bolt	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	5143675
AN4-4A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5148667
D2965	Cap	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5015487
D3508-11	Wearplate Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5146337
D3508-13	Wearplate Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5148273
D3508-3	Wearplate Fwd Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5148273
D3508-9	Wearplate Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5145477
D3558-11	Gasket Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5146259
D3558-13	Gasket Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5122527
D3558-3	Gasket Center Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5177341
D3558-9	Gasket Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5177339
NAS1149C0332R	Washer	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	5148666
NAS1149D0332J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5128446
NAS1149D0416J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	514631511

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
130-Skidtubes - 1	D3582-1-BENT	1	2	0
	D5520-1	2	14	0
	D2964	1	13	0
140-Skidtubes - 2 - B4B	CR3212-5-05	68	1,225	0
	D2971	1	22	0
	D3584-1	1	3	0
190-Skidtubes - 3 - B4B	D3662-1	3	6	0
	D3662-3	1	15	0
	D5304-1	2	39	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	36	8,891	0
	ALS4-428-165	2	88	0
	AN3-5A	2	331	0
	AN3C4A	28	1,611	0
	AN4-4A	2	45	0
	D2965	1	71	0
	D3508-11	1	6	0
	D3508-13	1	6	0
	D3508-3	1	9	0
	D3508-9	1	6	0
	D3558-11	1	3	0
	D3558-13	1	4	0
	D3558-3	1	2	0
	D3558-9	1	2	0
	NAS1149C0332R	28	4,345	0
	NAS1149D0332J	2	3,628	0
	NAS1149D0416J	2	2,050	0

Part Specifications

Specifications could not be found.

ITEM	Qty -041	Part Number	Description
	X	D3582-041	SKIDTUBE ASSEMBLY
1	1	D2962-150	EXTRUSION
2	1	D2964	CAP
3	1	D2965	CAP
4	1	D2971	CROSS BOLT SPACER
5	1	D3508-3	WEARPLATE
6	1	D3508-9	WEARPLATE
7	1	D3508-11	WEARPLATE
8	1	D3508-13	WEARPLATE
9	1	D3558-3	GASKET
10	1	D3558-9	GASKET
11	1	D3558-11	GASKET
12	1	D3558-13	GASKET
13	1	D3584-1	WEB
14	3	D3662-1	CROSS BOLT SPACER
15	1	D3662-3	CROSS BOLT SPACER
16	2	D5304-1	CROSS BOLT SPACER
17	2	D5520-1	DOUBLER
18	28	AN3C4A	BOLT
19	2	AN3-5A	BOLT
20	2	AN4-4A	BOLT
21	28	NAS1149C0332R	WASHER (AN960C10L)
22	2	NAS1149D0332J	WASHER (AN960JD10L)
23	2	NAS1149D0416J	WASHER (AN960JD416L)
24	36	AELS-1032-130	INSERT
25	2	ALS7-428-165	INSERT
26	68	CR3212-5-05	CSK RIVET, CHERRY MAX

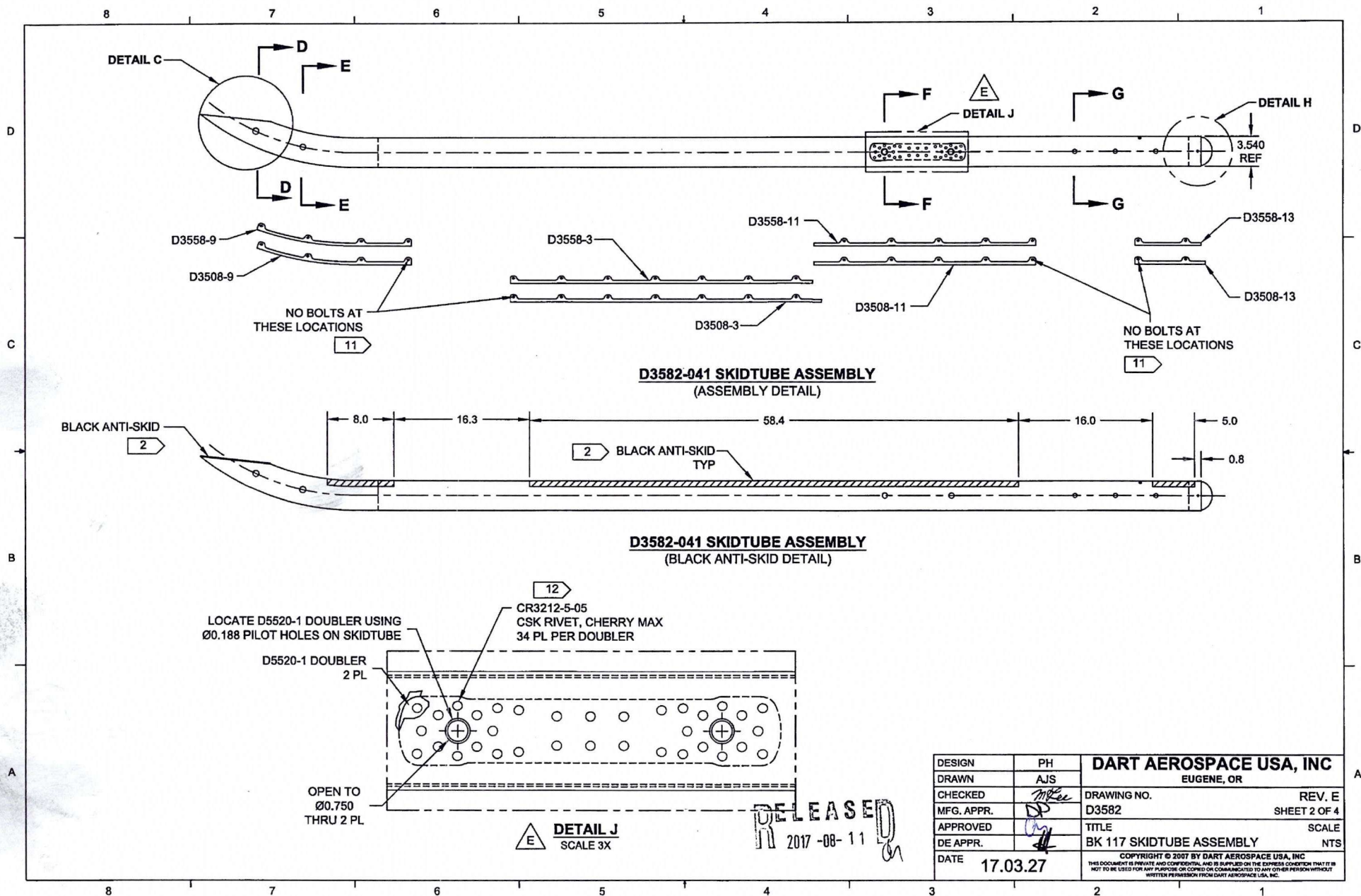
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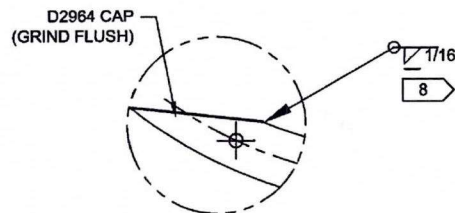
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 18.2 lbs
- 8) WELDING: PER DART QSI 004.
- 9) INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 10) USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 11) DO NOT INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS IN INDICATED LOCATIONS
- 12) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.161 THRU SKIDTUBE AND DOUBLER USING DT10309. COUNTERSINK Ø0.286 x 100° (34 PL) PER DOUBLER AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS.

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192998 MWS
1904-01

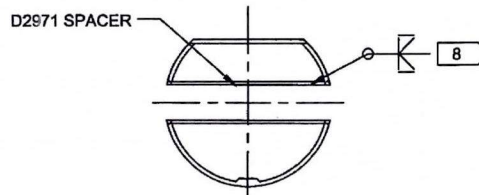
RELEASED
2017-08-11
EN 17-547

E	MOVE VIEWS FROM SHT 1 TO SHT 2. ADD ITEMS 17 & 26 AND NOTE 12-13. Ø0.187 HOLE WAS Ø0.75. ADD SHT 3. ADD DETAIL J. SECTION F-F ADD D5520-1. SCALE ON VIEWS WAS 3X.	AJS	17.03.27
D	D5304-1 WAS D2973; REVISE BOM & SECTION F-F & SECTION NOTES (ZN B7-3, A8-3); REF NCR16-6160	RF	17.01.09
C	D3492 PLUG ASSEMBLIES REMOVED. REFORMAT NOTES SHT 1	AP	15.11.02
B	29.86 WAS 29.87 (ZN C2-1), INCORPORATED DEO D3582-A-1 (ZN D5-1), FORMAT TO CURRENT STD	RF	15.02.20
A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	EUGENE, OR	
CHECKED	MJS	DRAWING NO.	REV. E
MFG. APPR.	DP	D3582	SHEET 1 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BK 117 SKIDTUBE ASSEMBLY	NTS
DATE	17.03.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



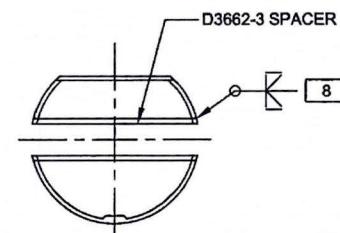


DETAIL C
SCALE 4X



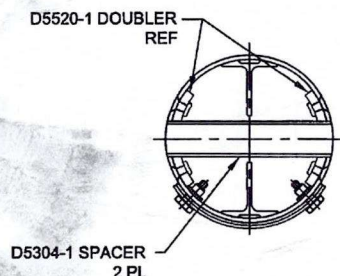
SECTION D-D
SCALE 4X

- SECTION D-D NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D2971 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS Ø0.750 DRILL TO REMOVE SPILL OVER



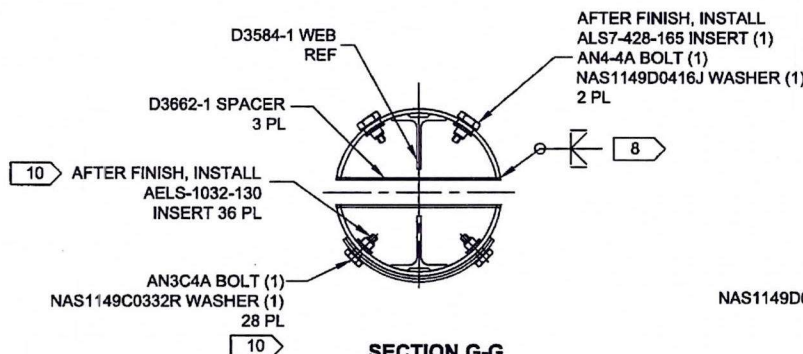
SECTION E-E
SCALE 4X

- SECTION E-E NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3662-3 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS Ø0.672 DRILL TO REMOVE SPILL OVER



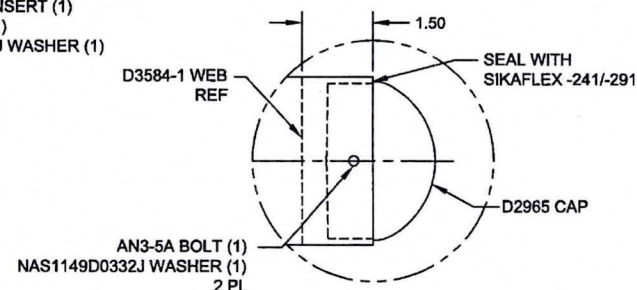
SECTION F-F
SCALE 4X
2 PL

- SECTION F-F NOTES**
AFTER BENDING AND DRILLING ASSY
PERFORM THE FOLLOWING:
1. INSERT D5304-1 SPACER
 2. SWAGE TO Ø0.565 +0.005/-0.000 X 1.0 DEEP PER QSI 002
 3. OPEN THRU HOLE TO Ø0.625
 4. GRIND FLUSH



SECTION G-G
SCALE 4X

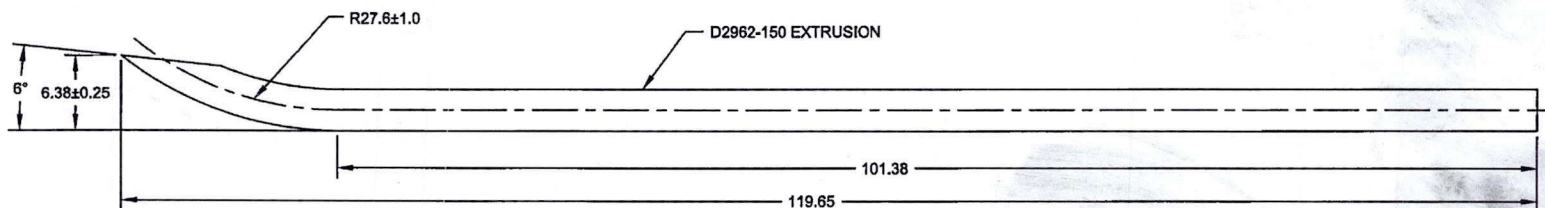
- SECTION G-G NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3662-1 SPACER (3 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS Ø0.515 DRILL TO REMOVE SPILL OVER



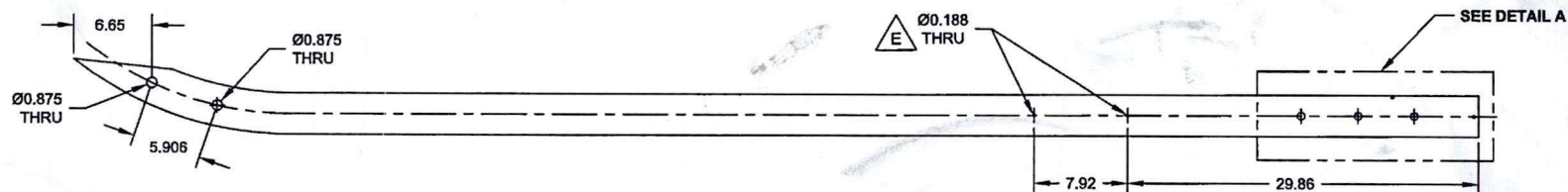
DETAIL H
SCALE 4X

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	EUGENE, OR	
CHECKED	M. Lee	DRAWING NO.	REV. E
MFG. APPR.		D3582	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BK 117 SKIDTUBE ASSEMBLY	NTS
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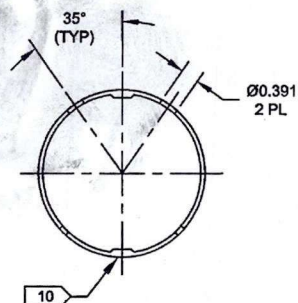
RELEASED
2017-08-11



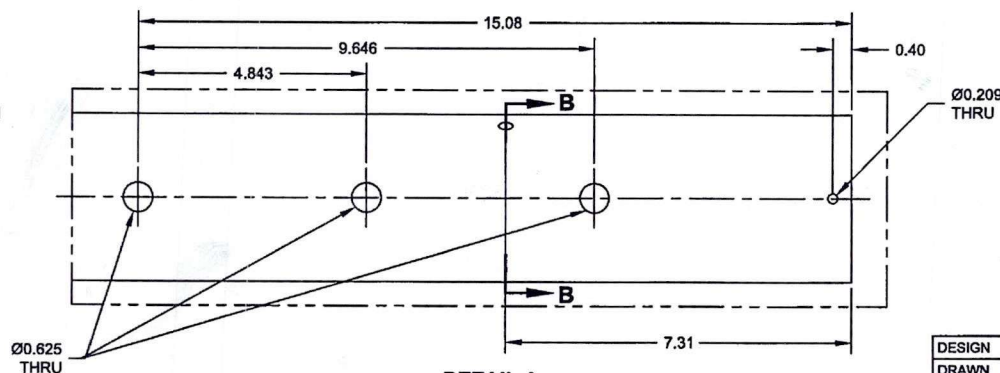
D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 5X



DETAIL A
SCALE 5X

RELEASED
2017-08-11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	EUGENE, OR	
CHECKED	<i>M. Lee</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>PS</i>	D3582	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BK 117 SKIDTUBE ASSEMBLY	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					